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TITLE: ULTRASONIC WELDING STATE INSPECTION DEVICE

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ABSTRACT:

PURPOSE: To enable accurate and efficient inspection even if a body to be inspected shifts in welding position by employing the minimum value among the numbers of defects corresponding to width-directional measurement points obtained by inspecting a weld zone as evaluation data on an article to be inspected.

CONSTITUTION: A data processor 1 has the external memory 7 of a microprocessor 6, etc., internally and the memory 7 is stored with a **defect** detection processing program 8a and a quality decision processing program 8b. The **defect** detection processing program 8a makes a scan in a welding

direction with an **ultrasonic** probe, and then moves the **ultrasonic** probe by specific pitch in the width direction of the **weld zone**; and data on echo levels of respective measurement points obtained by further movement in the welding direction are compared with a reference value to detect and count defects. The number of the defects is stored in the memory 7. The quality decision processing program 8b selects the minimum value among the numbers of defects corresponding to the respective width-directional measurement points stored in the memory 7 to obtain the evaluation data, which is compared with the criterion value to decide whether a work 1 is normal or not. Consequently, even if the body to be inspected shifts in welding position, the accurate inspection is performed.

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